

Work Order ID 74172

Monday, September 26, 2011 2:45:12 PM



Page 1

Item ID: D205-634-141

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 9/26/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN D205-634

G

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-141 CHG001

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

see previous
w/ O

#76548

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
Skidtubes		0.00							
Skidtubes	Memo 1- Deburr ends and remove bending marks 2- Prepare tube for welding as per QSI 004								
130	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

see
w/o 76548
W

W/O:		WORK ORDER CHANGES					
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Customer:

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Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R□□□ Aluminum Rod

2-Grind welds on step as per Dwg D2580

3-Weld spacers as per dwg D2580

4- *** N/A**** Insert D4202-1 spacer, swage as per QSI002 and trim/ grind
flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2
x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension.

5-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

6-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

*Drill holes for run on wearplate as per dwg D2580 page 7**DP 11-11-24*

150

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

*See w/o
76548**h*

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
170 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.	0.00 0.00							
180 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.00							

See w/o
76548
W

W/O:		WORK ORDER CHANGES					
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Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 BR 11-11-30

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1 BR 11-11-30

1-Install wearplates as per Dwg. D2580.

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R ☐ ☐ ☐ Sikaflex-291 ☐ 119443
Sikaflex expire date: 6-1.5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: 118788

W/O:		WORK ORDER CHANGES					
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Start Date: 9/26/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

11/12/12 01 (1)

220

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-141

Location: _____

PPP Rev: _____

PP 74162

11/12/12

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/12/12

mf 11-12-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Monday, September 26, 2011 2:45:09 PM

Page 1

Work Order ID: 74172

Parent Item: D205-634-141

Parent Item Name: Replacement Skidtube



Start Date: 9/26/2011

Required Date: 10/14/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA 11.09.14 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-45A 		Purchased	No				Each	200.0000		8			
Bolt													

Location	Loc Qty	Loc Code
----------	---------	----------

ST349	200	
118926 ✓	200	

D2570 		Manufactured	No				Each	122.0000		16			
Bushing													

Location	Loc Qty	Loc Code
----------	---------	----------

ST0 *7216*	122	
66933	1	
67759 ✓	6	
72122	1	
72960	72	
73636	42	

D4202-1 		Manufactured	No				Each	443.0000		20			
Spacer													

Location	Loc Qty	Loc Code
----------	---------	----------

LG002	443	
66929	106	
67129	196	
67308	1	
67430	140	

D205-634-041 B# 76335

BR 11-12-1

BR 11-12-1

see w/o 76548

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Monday, September 26, 2011 2:45:09 PM

Work Order ID: 74172

Parent Item: D205-634-141

Parent Item Name: Replacement Skidtube

Start Date: 9/26/2011

Required Date: 10/14/2011

Start Qty: 1.00

Required Qty: 1.00

D4406-041

Manufactured No

Each 1.0000



Fwd Wearplate Assembly



1

BL 11-11-30.

Location

Loc Qty

Loc Code

ST

74147

1

71909

1

D4406-043

Manufactured No

Each 1.0000



Aft Wearplate Assembly



1

BR 11-12-1.

Location

Loc Qty

Loc Code

ST

72640

1

1

MS21042-4

Purchased No

Each 252.0000



USE MS21042L4



8

BL 11-12-1.

Location

Loc Qty

Loc Code

ST299

119017.

252

100743

9

5389

78

5461

3

6844

19

7690

24

8182

115

9229

4

D2580-1

Manufactured No

Each 1.0000



205 Skidtube bent detail



1

see w/o 76548

Location

Loc Qty

Loc Code

LG

72965

1

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 74172

Parent Item: D205-634-141

Parent Item Name: Replacement Skidtube

Start Date: 9/26/2011

Required Date: 10/14/2011

Start Qty: 1.00

Required Qty: 1.00

D25763 Manufactured No

Each 72.0000

1



Step (maching detail)

See w/o 76548

Location
LG

Loc Qty

Loc Code

66156
70883

72
22
50

D2855 Manufactured No

Each 18.0000

1



Cap

Location

Loc Qty

Loc Code

FP007 73347
65519
65569

18
2
16

1.

AN3-SA Purchased No

Each 886.0000

2



Bolt

Location

Loc Qty

Loc Code

ST350
115371
117423 ✓
118626

886
46
540
300

2.

AN960JD10L * NAS1149D0332h ✓ Purchased No

Each 0.0000

2



Washer

118388

2.

BR 11-12-1.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Page 4

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Parent Item: D205-634-141



Parent Item Name: Replacement Skidtube

Start Date: 9/26/2011

Required Date: 10/14/2011

Start Qty: 1.00

Required Qty: 1.00

D2594-3

Manufactured No

Each

884.0000

8



O-Ring, 205 Skidtube

BR 11-12-1.

Location

Loc Qty

Loc Code

FP004

198

73490

198

FP-A

686

65518

41

66952

347

73490

298

8.

D2594-1

Manufactured No

Each

254.0000

8



Plug, 205 Skidtube

BR 11-12-1.

Location

Loc Qty

Loc Code

FP

172

73401

172

FP-A

82

42807

28

67441

7

72127

47

8.

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Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
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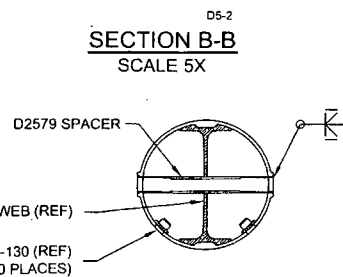
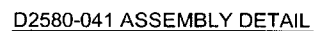
LIST OF MATERIALS					
ITEM	QTY -041	QTY -045	QTY -047	PART NUMBER	DESCRIPTION
1	X			D2580-041	SKIDTUBE ASSEMBLY
2		X		D2580-045	SKIDTUBE ASSEMBLY
3			X	D2580-047	SKIDTUBE ASSEMBLY
4	1	1	1	D2500-1-190	EXTRUSION
5			16	D2570	BUSHING
6	1	1	1	D2576-3	STEP
7	20	24	25	D2579	SPACER
8	16	16	8	D2594-1	PLUG
9	16	16	8	D2594-3	O-RING
10	1	1	1	D2596	205 WEB
11	1	1	1	D2855	AFT CAP
12	1	1		D3564-5	WEARSHOE
13	1	1		D3564-9	WEARSHOE
14	1	1		D3564-11	WEARSHOE
15	1	1		D3564-13	WEARSHOE
16	2	2		D3566-1	GASKET
17	1	1		D3566-5	GASKET
18	1	1		D3566-13	GASKET
19			1	D4406-041	WEARPLATE ASSEMBLY
20			1	D4406-043	WEARPLATE ASSEMBLY
21	50	50		ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
22	50	50		AN3C4A	BOLT
23	2	2	2	AN3-5A	BOLT
24			8	AN4-45A	BOLT
25	50	50		NAS1149C0332R	WASHER (AN960C10L)
26	2	2	2	NAS1149D0332J	WASHER (AN960JD10L)
27			8	MS21042-4	NUT (OR MS21042L4)

GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY (-041/-047) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
POWDER COAT ASSEMBLY (-045) GREEN SANDEX (REF 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2580-041 = 34.5 lbs
D2580-045 = 34.5 lbs
D2580-047 = 37.7 lbs
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DT8217 & DT8937 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/291.
- 12) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

RELEASED
2011-08-29
WD

E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8937 WAS TD2577-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	PH	07.04.05
C	REDRAWN, INCLUDED DEO 9094/9097	CP	98.08.26
B	AS MANUFACTURED	DS	96.12.02
A	NEW ISSUE	DS	96.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	#		
DRAWN	RF		
CHECKED	10		
MFG. APPR.	10		
APPROVED	10		
DE APPR.	10		
DATE	11.06.21		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2580 TITLE 205 SKIDTUBE ASSEMBLY COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			
		REV. E	SHEET 1 OF 8
		SCALE	NTS



DETAIL C
SCALE 5X

D3-2

2011-08-29

GRIND FLUSH
4 PL

GRIND FLUSH

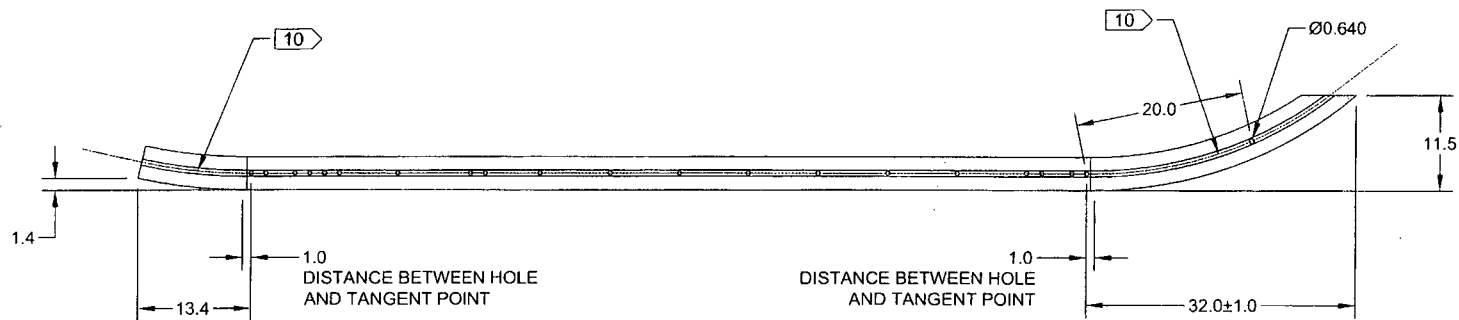
D2576-3 STEP

GRIND FLUSH

LOCATION RIDGE
ON UNDERSIDE
OF D2576-3

1/4"

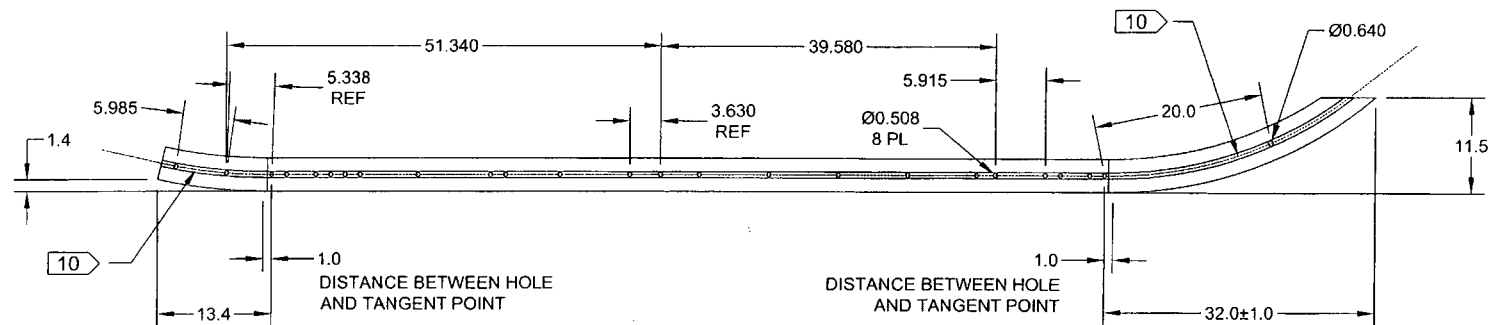
DESIGN	#	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. 1
MFG. APPR.	N	D2580	SHEET 2 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	205 SKIDTUBE ASSEMBLY	
DATE	11.06.21	COPYRIGHT © 1998 BY DART AEROSPACE LTD	
<small>THIS DOCUMENT IS PRINTED IN FULL. IF THE ENTIRE CONTENTS OF THIS DRAWING ARE NOT SHOWN, IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>			



D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

RELEASED
11 2011-08-28
JW

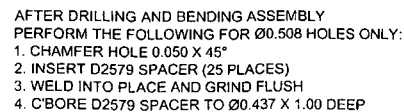
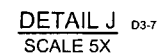
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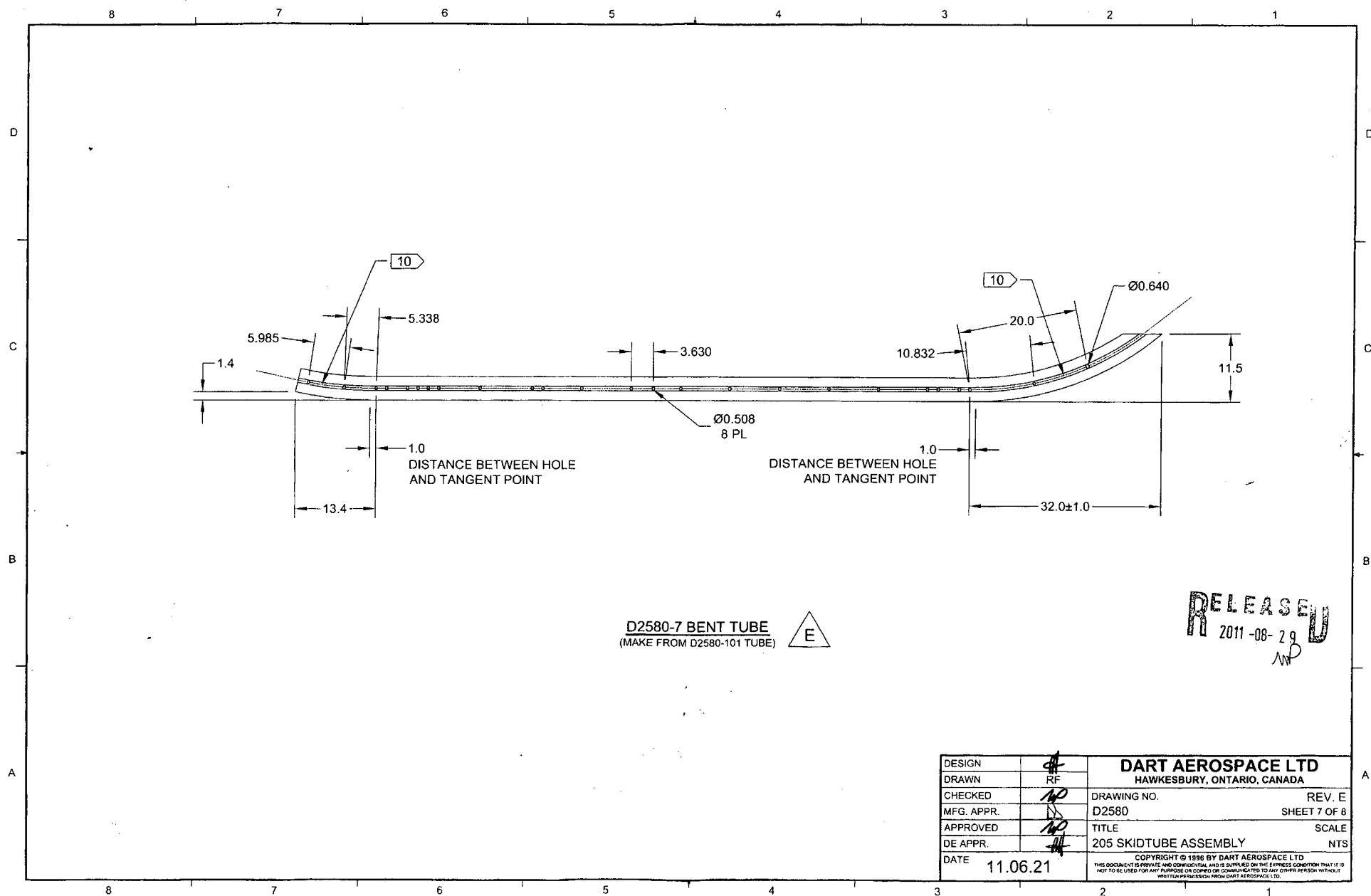
D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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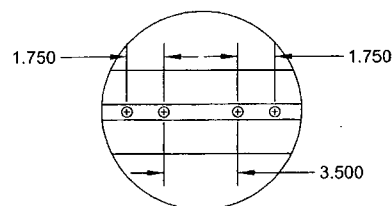
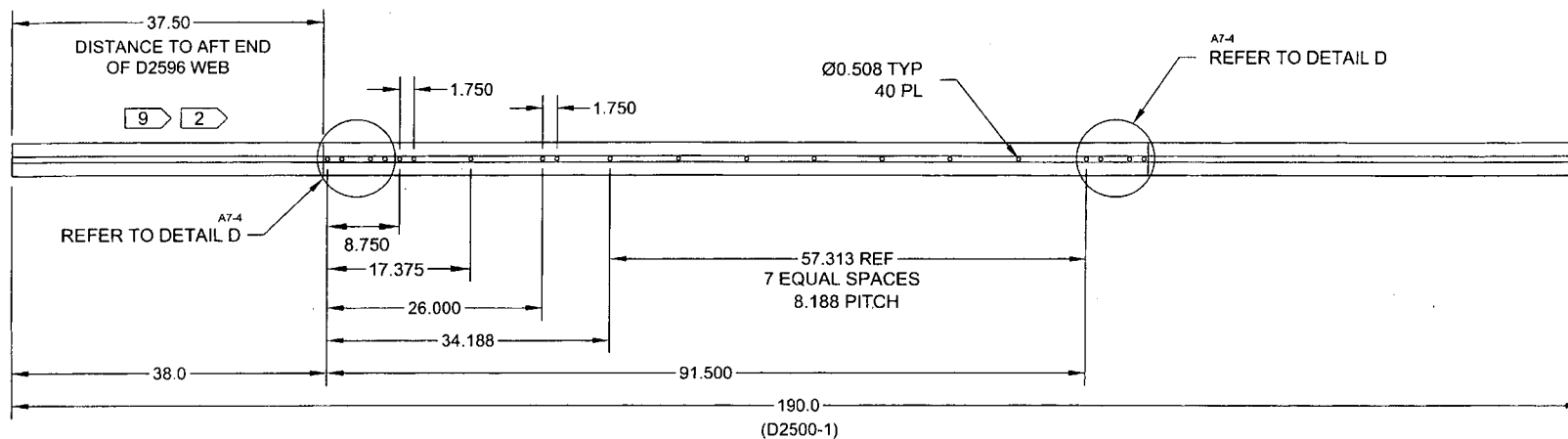


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SCALE 5X C7-4

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